Work Order ID 70773 Wednesday, June 15, 2011 9:09:12 AM													Page 1	
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3413-1 Ring 6/15/2011 6/22/2011	Start Qty: 40.0 Req'd Qty: 40.0		1 JERNY BIRW REW KAR 1 Dewis Brail 1814 IRA	Accept	Cu	ast Item I	IIII IIII II			Setup	Start		
Approvals:	Process Pla	n:	Date:	1-06e/5	Tooling: SPC (Y/N):			ite:		Ì	Run	Start Stop		
Sequence ID/ Work Center II)	Operation Description	·		Set Up/ Run Hours	Т	ool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr D3413	Rev	ision Nbr A										-		
Waterjet FLOW CNC Waterjet 304.350.	. 11	Dwg Rev Prog Rev	per Dwg D34	13	0.00			. ·	i i	<u>R11-</u>	6-30	<u>ن</u>	(25
QC Quality Control		QC2- Inspect parts of Memo	f machine FA	/FAIB	0.00				4.	BII-	<u>(</u> -(-	30	 .	
120 QC		QC8- Inspect parts - s	econd check		0.00 Lilo	7/04				(ocen-) top			

Memo

Quality Control

Work Order ID 70773

·Wednesday, June 15, 2011 9:09:12 AM



Page 2

Item ID:

D3413-1

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Required Date: 6/22/2011

Ring

6/15/2011

Start Qty: 40.00

Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals:

Sequence ID/

Process Plan:

Date:

Tooling:

Date:

Date:

Run Start

Stop



Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Work Center ID 130

Small Fab Small Fab

Small Fab

Operation

Description

Memo

Memo

0.00

0.00

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1.

140

QC5- Inspect part completeness to step on W/O

S1107/07

Quality Control

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

150

Powder Coating

Memo

□OVEN TEMPERATURE:

25XJ Mf 4/07/07

M11745

Work Order ID 70773

Wednesday, June 15, 2011 9:09:12 AM



Page 3

Item ID:

D3413-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Ring

Start Date: 6/15/2011

Required Date: 6/22/2011

QC:

Start Qty: 40.00 Req'd Oty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/

Work Center ID

160

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

170

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

180

QC Quality Control QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Picklist Print

Wednesday, June 15, 2011 9:09:19 AM

Work Order ID: 70773

Parent Item: D3413-1

Parent Item Name: Ring



Start Date: 6/15/2011

116808

Required Date: 6/22/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A□05.09.13□New issue□KJ/JLM IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	8.2000	0.25	10.52632			
										BIL	-6-3	\circ	

304 BAR .250 x 4.00

Location Loc Qty Loc Code MAT050 8.2 116808 8.2



DART AEROSPACE LTD	Work Order:	70173
Description: Ring	Part Number:	D3413-1
Inspection Dwg: D3413 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.88	+/-0.030	3.872	Sec.		V BUZ	
Ø2.00	+0.012/-0.001	5,003	X		V	
0.75	+/-0.030		بخر		V	
Ø0.266	+0.006/-0.001	.766	25		V	
0.250	+/-0.010	.766 -748	-		V	
or constru						
\$ 14 P P						

Measured by:	В	Audited by:		Prototype Approval:	N/A
Date:	11-6-30	Date: ι	407/64	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.09.06	New Issue	KJ/JLM of	E
			, (1	

Dart Aerospace Ltd

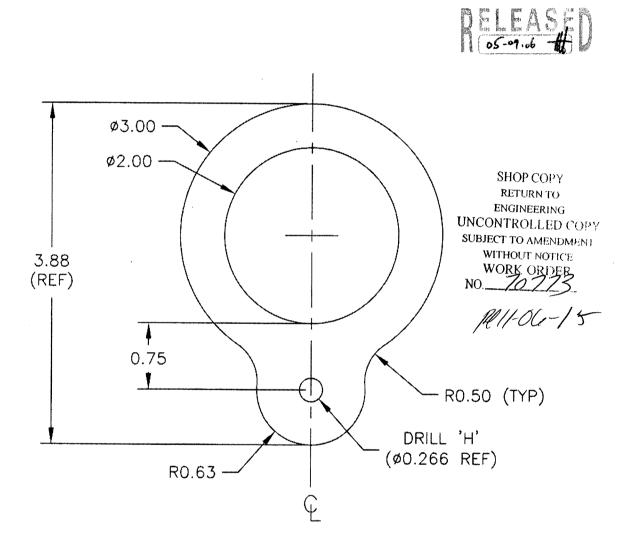
- u	·oopaoo	m.v								
W/O:		*	WC	ORK ORDER CHANG	SES					
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	PAR #: Fault Category:				No DQ	A: Date:		
Resolution:			Dispositio	QA:	QA: N/C Closed: Date:					
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section			Verifica			Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

^{*}H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



DESIG	CP.	DRAWN BY	DART	AEROSPACE PORT HADLOCK, I		INC.
CHEC	KED #	APPROVED	D3413		SH	REV. A EET 1 OF 1
DATE			TITLE		······································	SCALE
05.0	3.16		RING			1:1
Α		05.03.16	NEW ISSI	JF		



D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					·				;
Part No:		PAR #:	egory:	NCR: Ye	s No D	QA:	Date: _		
		esolution:							
NCR:	,		WORK ORD	DER NON-CONFORMAI	NCE (NO	CR)			
DATE	STEP	Description of NC		Corrective Action Section		Veri	fication	Approval Chief Eng	Approval QC Inspector
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da	ı& ∣ _{Se}	ction C		
<u> </u>									

NOTE: Date & initial all entries